

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000435**Date Inspected:** 13-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	n/a	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes No N/A	<b>Rod Oven in Use:</b>	Yes No N/A	
<b>Electrode to specification:</b>	Yes No N/A	<b>Weld Procedures Followed:</b>	Yes No N/A	
<b>Qualified Welders:</b>	Yes No N/A	<b>Verified Joint Fit-up:</b>	Yes No N/A	
<b>Approved Drawings:</b>	Yes No N/A	<b>Approved WPS:</b>	Yes No N/A	
		<b>Delayed / Cancelled:</b>	Yes No N/A	
<b>Bridge No:</b>	34-0006	<b>Component:</b>	MTR's	

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

**Material Test Reports:**

Quality Assurance (QA) Inspector Brannon observed material received in the ZPMC yard batch #13. There were a total of 60 out of 67 plates received with plate thicknesses ranging from 10mm to 20mm. The plates were all ASTM A709-345T2, ASTM A709M-345T2-X and ASTM A709M-345F2-X plate material and were accompanied with material test reports (MTR). The MTRs could not be reviewed on the day the plates were observed for their general condition and markings but will be reviewed at the earliest opportunity. QA Inspector Brannon assigned lot number B22-031-07 to this lot of plate.

**Component Material Inspection:**

QA Inspector Brannon visual inspected (VT) and green tagged eight (8) reinforcement ring plates for the 77 meter mock-up for the purpose of shipping to Wu Xi HuaGuang Boiler Co., LTD for bending to various degrees. QA Inspector was accompanied by ZPMC Mr. Xu Jun and ABF Mr. Jeff Evans. Items green tagged are as follows:  
Sub Assembly-SA273 Part ID-P1022-90°, P615-90°, P585-30° and SA273-150°.  
Sub Assembly-SA274 Part ID-P1082-90°, P1086-90°, P583-30° and SA274-150°.

The QA Inspector Brannon assigned Caltrans lot # B22-032-07 to the reinforcement ring plates. This Caltrans 6031 report is supported by (1) Caltrans 6011 report for this date.

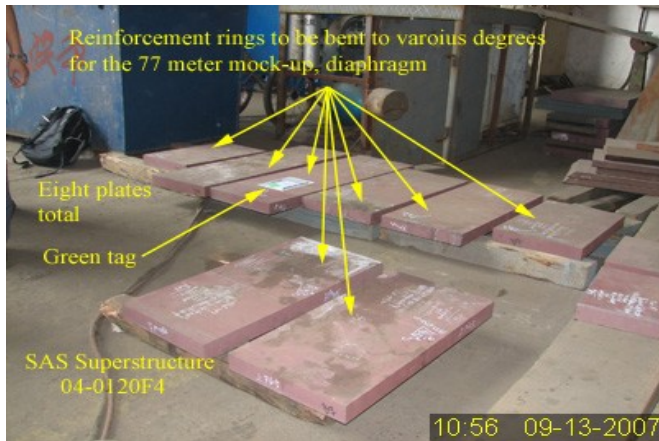
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## WELDING INSPECTION REPORT

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The following digital photograph illustrates the eight (8) reinforcement plates green tagged for bending.



### Summary of Conversations:

No relevant conversations on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Brannon, Sherri

Quality Assurance Inspector

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**Reviewed By:** Cuellar, Robert

QA Reviewer